Work Order ID 125139

125139

Page 1

Tuesday, Octob	ber 07, 2014 1	0:36:25 AM									
Item ID: Revision ID:	D3457-1		,	Accept	*N900	040	100)* s	Setup Sta	171	S1*
Item Name:	Washer								Sto	[™] *Ν	S2*
Start Date:	10/06/14	Start Qty: 12.00	*12*		Cust Item 1	ID:					
Required Date	e: 10/06/14	Req'd Qty: 12.00	*12*		Customer:						
Reference:								•			
Approvals:	Process Pla	n: りして	Date: 14-10-08	Tooling:	D	ate:		K	tun Sta	~! <i>\</i> J	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	, *V	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3457	Rev	A									
*100 *100*		DOOSAN LATHE		0.00				12			(1 1/4/1/2
Doosan Doosan Lathe		Memo Turn as per	Folio FA589 Rev: <u> </u>	0.00 Dwg D3457 Rev: <u>A</u>	-			_/		•	2/7/000
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
110 QC Quality Control		Мето		0.00				12		-	<u> </u>
120		QC8- Inspect parts - seco	ond check	0.00		./		•		٠	
120 QC Quality Control		Memo		0.00	and 14	10/20	2	12	B		

DQA:			Date:									,	***	AA RT
						WORK ORDER NON	-C(ONFO	RMANCE / UPI			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
WOIN OIG	٠,					Rework			Skid-tube	Water Jet			Engineering	
Part N	Vo.					Scrap			Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	\dashv	Quality
	-					Use-as-is			moforming	Finishing	-	re/Packaging	٦	Other
NCR I	۷o.		····			Ⅰ			Composite]	Supplier			
Root		,			Desc	ription of work order update		nitial	Actio	n	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification		QC Inspector
Design										, ,,,,,,			\Box	
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator			:	l										
Offset/Setup	Ш													
Process														
Supplier	Ш													
Training														
Transport														
Unapproved														
							FAL	JLT CAT	TEGORY					
Landi	ng G	iear			,	General					-	_	_	
		Bending				Bend		Folio/P	Program		Outside Dim	ensions	P	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	_ s	et-up
	Щ	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	t _	٦	emperature/Cure
	Щ	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	_ ^	Veld
	-	Cuffs				Contamination			ions Incomplete/Un	clear	Part Moved	Ĺ		Vrong Stock Pulled
	${f}$	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong	_	
	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/S	Surge	0	ther	
	Inspection Strip in Tube				Drawing		Misread	t						
	\vdash	Marks/Ch				Drill Holes		Off-set				· · · · · · · · · · · · · · · · · · ·		
	-	Turning S				Finish	Out of Calibration							
	Wave/Twist in Tube					Fit/Function	Out of Sequence							

Work O	der ID	12	25139
Tuesday, Oct	ober 07, 20	14	10:36:2
Itom ID:	D3457-	1	-

Work Ord Tuesday, October			*125139*								Page 1	Page 2
Item ID: Revision ID: Item Name:	D3457-1 Washer			Accept	*N900	040	100)* \$	Setup	Start Stop		S1* S2*
Start Date: 10/06/14 Start Qty: 12.00 Required Date: 10/06/14 Req'd Qty: 12.00 Reference:		*1:		Cust Item ID: Customer:								
Approvals:	Process Plan:		Date:	Tooling: SPC (Y/N):	Date:		Run			Start Stop		R1* R <i>2</i> *
Sequence ID/ Work Center I 130 *120* Packaging Packaging	D	Operation		Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
140 *1 \(\lambda \) \(\text{Control} \) QC Quality Control		QC21- Final Inspection - Memo	Work Order Releas	e 0.00 0.00						14	101	23 A) mr 14-10-22

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE									DART			
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / U		Vork Order up	odate only	AEROSPACE
						DISPOSITION					EPARTMENT,	· <u> </u>	
Work Orde	er: _										_		— ¹
D4 N	1 -					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۰۰۰ –					Scrap		Machining Small Fab				d. Eng. Coor.	Quality
NCR N	do.					Use-as-is Suspected Unapproved		Thermoforming Finishing Large Fab Composite			Rec/stol	re/Packaging Supplier	Other
· · · · ·	•••					Saspected Onapproved			carge rab	composite		20ppilet [
Root					Desci	ription of work order update	ı	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design						, and the second							
Doc/Data													
Equip/Tooling													
Handling/Pre												•	
Material													
Operator													
Offset/Setup													
Process							ı						
Supplier													
Training													
Transport													
Unapproved													
				·			FAI	ULT CAT	TEGORY				
Landir						General		1		F	-	-	_
,	_	Bending				Bend			rogram	<u> </u>	Outside Dim	 	Pressure/Forced
	\dashv	entre No	ot Concer	ntric		BOM/Route		Grain		-	Over/Under	-	Set-up
,		Cracks				Broken/Damage/Defect		Hardwa			Part Incorred	 	Temperature/Cure
		rimp/Kin	ık/Ripple	/Wave	<u> </u>	Burrs		1	on Incomplete/U	· —	Part Lost/Mi	ssing	Weld
,	$\overline{}$	Cuffs				Contamination		1	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	_	-	ned/off center	<u> </u>	Positioned W	_	_	
	Heat Treat				Cut Too Short	_	Mislabe			Power Loss/S	Surge	Other	
	$\overline{}$	nspection	,	Tube		Drawing	_	Misread	1				
	—	//arks/Ch				Drill Holes	-	Off-set					
		urning Se	•			Finish	Out of Calibration				<u></u>		
	Wave/Twist in Tube					Fit/Function		Out of Sequence					

Picklist Print

Tuesday, October 07, 2014 10:36:24 AM

Work Order ID: 125139

125139

Parent Item:

D3457-1

D3457-1

Parent Item Name: Washer

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A05.10.03New issueKJ/JLM

IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	62.7100	0.0208	1			
MDFLRINR1 000 ** 51 14-15-21													

Delrin Round Bar 1" color: black

Location	Loc Oty	Loc Code	
MAT039	62.71		
m128667	1.216	•	
m129774	1.494		
m130065	12		6.4
m130187	48		

DQA:			Date:										***	AART
QA Closed:			Date:			WORK ORDER NON	1-C	ONFO	RMANCE / U		Vork Order uj	odate only	\neg	AEROSPACE
						DISPOSITION				•	EPARTMENT			
Work Order	r: _						-,			-	•	 1		
Part No	o. _					Rework Scrap	Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.			Engineering Quality	
NCR No.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier		Other	
Root					Desc	ription of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	1	QC Inspector
Design Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator											:			
Offset/Setup]			
Process														
Supplier														
Training														
Transport														
Unapproved											:			
							FA	ULT CA1	EGORY					
Landing	g Ge	ear				General				,				
	E	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	٦	ressure/Forced
Γ	\Box	Centre No	t Concen	ntric		BOM/Route		Grain		Γ	Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	1	emperature/Cure
ļ		Crimp/Kin	ık/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified	Part Lost/Mi	ssing	\neg $_{v}$	Veld
	\Box	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		$$ $ $	Vrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	ا Vrong		
	F	leat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	\Box	Other
	T _I	nspection	Strip in	Tube		Drawing		Misread	I	_				
	N	Marks/Ch	atter			Drill Holes	Г	Off-set						· · · · · · · · · · · · · · · · · · ·
	Т	urning Se	equence			Finish		i	Calibration					
	Wave/Twist in Tube			e		Fit/Function		Out of Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	125139
Description: Washer	Part Number:	D3457-1
Inspection Dwg: D3457 Rev: A		Page 1 of 1

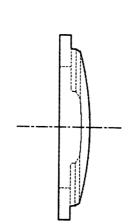
Inspection Dwg:	D3457 Re	v: A				Pa	ge 1 of 1
	FIRS	T ARTICLE II	NSPECTI	ON CHE	ECKLIST		
_		X First Arti		_	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ıments
R1.575	+/-0.010	1.575					
0.030 x 0.030	+/-0.010	+03×,030			ileen	11-10	71.0
0.530	+/-0.010	527			1	11210	
0.063	+/-0.010	-063				-	
0.169	+/-0.010	-168	/_		/		
Ø0.655	+/-0.010	-65+		-	/		
Ø1.000	+/-0.010	1.001	-/				
						174	
leasured by:	JL.	Audited by:	my		Prototype A	Approval:	N/A
Date:	14-10-21	Date:	14/10/	2.2		Date:	N/A
Rev Date A 08.11.28	Change New Issue					evised by	Approved

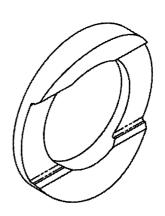
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Rev	Date	Change	· ·· -	Revised by	Approved
A	08.11.28	New Issue		KJ/EC	N N
				KO/LO S/X	



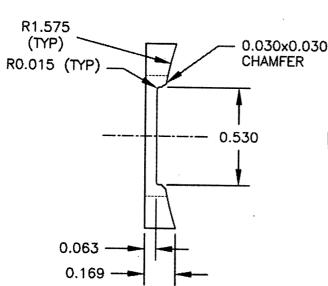
DESIG	CP	DRAWN BY	DART	AEROSPACE USA,	INC.
CHEC	KED #	APPROVED	DRAWING NO.	s	REV. A
DATE			TITLE		SCALE
05.0	09.06		WASHER		2:1
Α		05.09.06	NEW ISSU	JF	

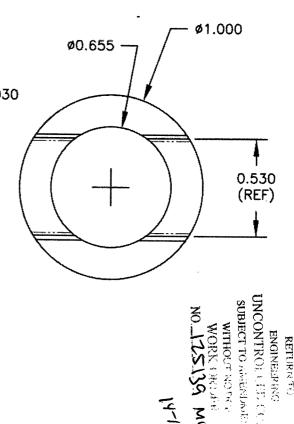






ISOMETRIC DETAIL





ENGINEURING

D3457-1 WASHER

1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)

2) FINISH: NONE

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

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